

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017929**Date Inspected:** 31-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of weld joints EP157-001-031, 032 located on PCMK OBG 11BE/11CE, transverse joint, edge plate I-rib to edge plate I-rib, north (crossbeam) side. Welder was identified as 040320. QC was identified as ZPMC QC Liu Hua Jie (QC1). Welding variables recorded by QC1 appeared to comply with WPS-B-P-2214-B-U2-FCM-1 as verbally identified by QC1.

FCAW welding of weld joints SP354-001-025~026 and SP355-001-001~012 located on PCMK OBG 11BE/11CE, on both sides of transverse joint, side plate T-rib web to side plate holdback welds, south (bikepath) side. Welders were identified as 047353, 044473. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-T-2132 as verbally identified by QC1.

SMAW tack welding of unidentified weld joints located on PCMK OBG 11CE/11DE, transverse joint, side plate T-rib web to side plate T-rib web, south (bikepath) side. Welder was identified as 042280. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2213-FCM-1 as verbally identified by QC1. QC1 informed this QA Inspector that he was not able to identify the welds because during the fitting and tacking process ZPMC QC personnel do not record that information.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW tack welding of temporary longitudinal alignment plates located on PCMK OBG 11CW/11DW, across transverse joint, one plate on each side of side plate to bottom plate longitudinal weld, south (crossbeam) side. See photo below. Welder was identified as 053475. QC was identified as ZPMC CWI Shi Lei (QC2). Welding variables recorded by QC2 appeared to comply with WPS-B-P-2214-FCM-1.

SMAW tack welding of temporary longitudinal alignment plates located on PCMK OBG 11CW/11DW, across transverse joint, one plate on each side of side plate to bottom plate longitudinal weld, north (counterweight) side. Welder was identified as 218707. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-P-2214-FCM-1.

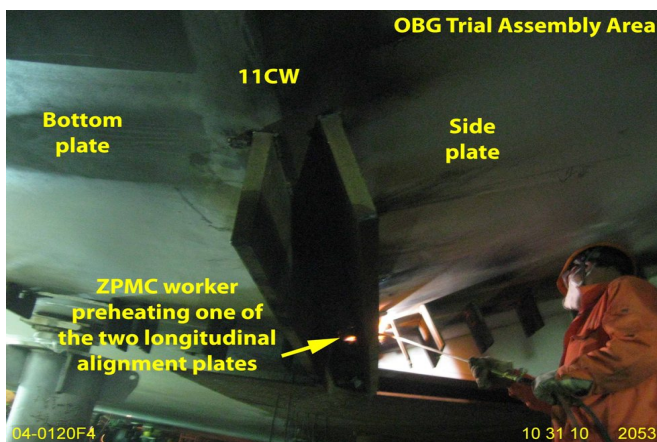
SMAW tack welding of unidentified weld joints located on PCMK OBG 11CW/11DW, transverse joint, bottom plate T-rib web to bottom plate T-rib web. Welders were identified as 218711, 218714. QC was identified as QC2. Welding variables recorded by QC2 appeared to comply with WPS-B-P-2213-FCM-1 as verbally identified by QC2. QC2 informed this QA Inspector that he was not able to identify the welds because during the fitting and tacking process ZPMC QC personnel do not record that information.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. OBG segment 10E was positioned on the ship moored to the end of the Heavy Dock. No work was being performed on any of the tower or OBG components. No floating crane was moored to or in the area of the Heavy Dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
